

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y
Job Number	: 33777		
Estimate Number	: 10360		
P.O. Number	: N/A	Part Number	: D2350
This Issue	: 7/30/2007 S.O. No. : N/A	Drawing Number	: D2350 / D2363
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B / E
Previous Run	: 31883	Material	: N/A
Written By	:	Due Date	: 8/12/2007 Qty:
Checked & Approved By	: [Signature] 07.07.30		Um: Each
Comment	: est rev B 06.05.17 added ass'y EC		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 D6201 T Extrusion 4X4X3/8



**Comment:** Qty.: 1.0631 f(s)/Unit      Total : 4.2525 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch: B29367

61''

20	BAND SAW	BAND SAW
----	----------	----------



**Comment:** BAND SAW

Cut blanks: 12.150" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

SA/SL 07.10.20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.10.20

5.0      QC8      SECOND CHECK



Comment: SECOND CHECK

07.10.22

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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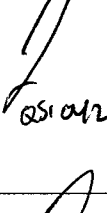


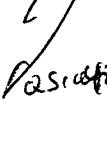
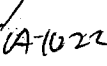
**Comment:** HAAS CNC VERTICAL MACHINING #1

### Tumble & deburr

SA 07.10.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2350 PAR #: N/A Fault Category: Prod / Machine <sup>pax</sup> NCR: Yes No DQA: Yes Date: 07/10/30  
 QA: N/C Closed: Yes Date: 07.10.29

NCR: <u>33777</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/20	3.0	- 1 part moved while machining R.C. Blanks were cut too long		Scrap and No Replace	SA 07/10/22	En 07/10/22		
07/10/22	#30	1 part blank was cut too short. R.C. Hammer error		Scrap and No Replace	SA 07.10.22	En 07/10/22		
07/10/22	#30	Chatter marks found on corners. one has a under cut in it		Scrap No replace	SA 07/10/22	En 07/10/22		

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:51:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 33777

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

~~SP~~ 07.10.23

(7)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/10/24

(7X)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/10/25

(7X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-25

(7X)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener

31924

SP

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin

3  
33825

SP

5

33795

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer

1104374

7/10/26 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:51:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 33777

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3

Nut (or -3)

M104625

sd

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13

Screw

M13719

7/10/26 sd

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

07/10/26 (7x)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/26 (7x)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57185

(7)

07/10/30 AS

U

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7)  
07/10/30

Job Completion



U 07.10.30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 33777
<b>Description:</b> Litter Tie Down Bracket		<b>Part Number:</b> D2363
<b>Inspection Dwg:</b> D2363	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.004	/			
1.70	+/-0.030	1.680	/			
1.00	+/-0.030	1.000	/			
4.00	+/-0.030	3.987	/			
1.50	+/-0.030	1.502	/			
0.50	+/-0.030	.489	/			
0.750	+/-0.010	.750	/			
1.50	+/-0.030	1.501	/			
4.250	+/-0.010	4.247	/			
0.75	+/-0.030	.753	/			
1.000	+/-0.010	1.007	/			
1.250	+/-0.010	1.244	/			
Ø0.191	+0.005/-0.001	Ø.191	/			
1.625	+/-0.010	1.622	/			
2.00	+/-0.030	1.999	/			
2.875	+/-0.010	2.868	/			
3.425	+/-0.010					
10.500	+/-0.010	10.497	/			
12.00	+/-0.030	11.996	/			
Ø0.242	+0.005/-0.001	Ø.242	/			
0.500	+/-0.010	.4965	/			
5.75	+/-0.030	5.746	/			
3 3/8	±.030	3.304	/			

<b>Measured by:</b> SA	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07.10.20	<b>Date:</b> 07/10/20	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.11.22	New Issue P/O D2350	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. F	KJ/JLM	BE



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED [Signature]	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED  
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
1	AD960JD10 L	WASHER
1	MS21042LB	NUT
1	MS27039-A-13	SCREW

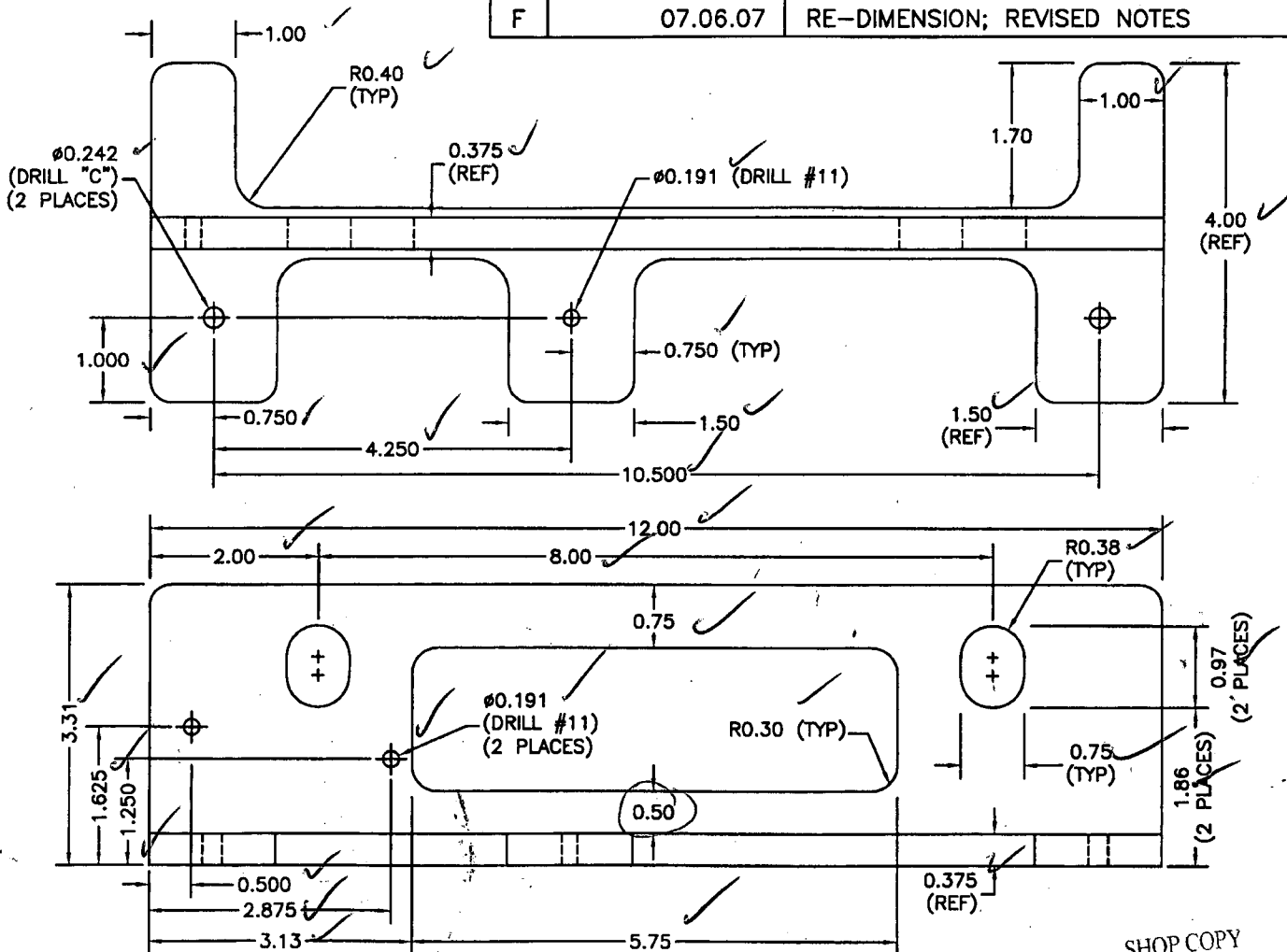
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WORK ORDER  
NO. 33717



**DART**

DESIGN BW	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER TIE DOWN BRACKET	SCALE 1:2	
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3 SUBJECT TO AMENDMENT WITHOUT NOTICE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

**RELEASED**

07.06.22 [Signature]

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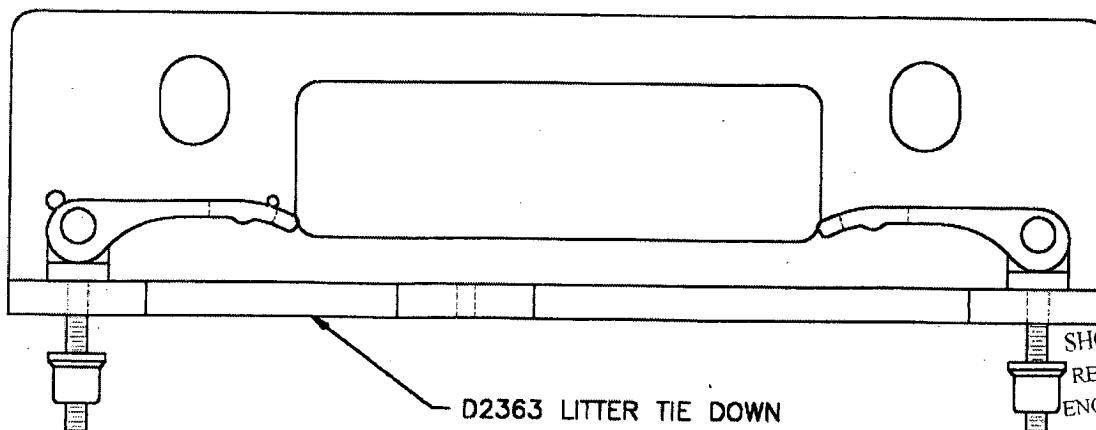
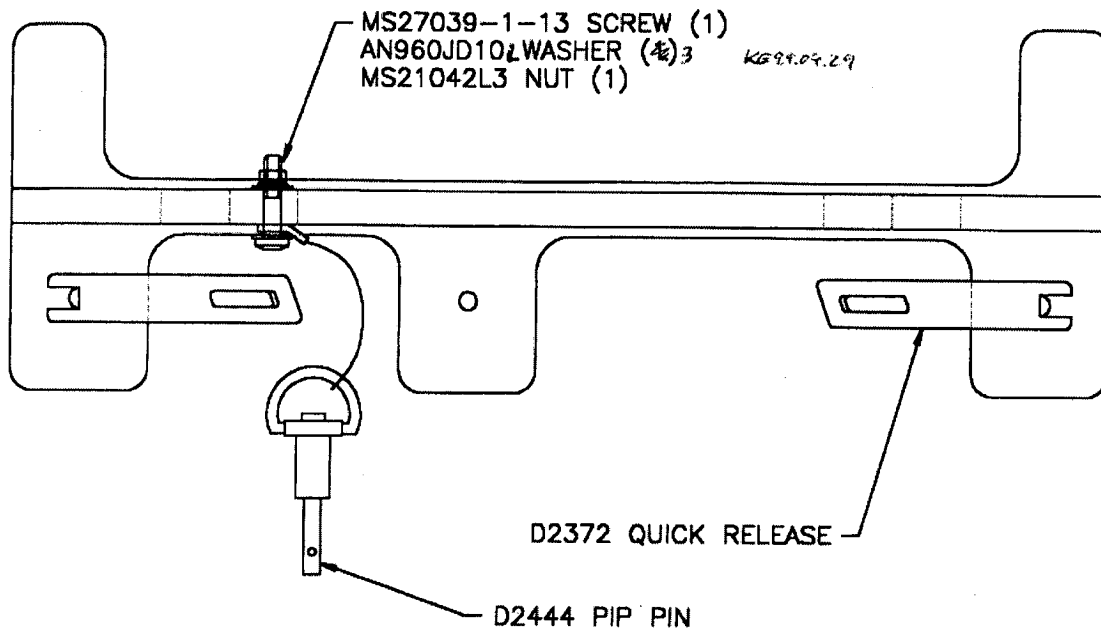
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED B W	APPROVED <i>[Signature]</i>	D2350	SHEET 2 OF 2
DATE	TITLE		SCALE
95:02:20	LITTER TIE DOWN ASSEMBLY		

RELEASED  
960607



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WITHOUT NOTICE  
WORK ORDER  
NO. 33777

**DART Aerospace Ltd**

**CUSTOMER RETURN**

#R08-011

Initiator: JEAN KERR Date: FEB. 4/08  
 Company: MUSTANG Helicopters Invoice # 5610  
403 886-5995 Order Entry # 5134  
 Phone No. CMUS101  
 Reason for return: Ordered incorrect part. Attach Copy of DHS Return Authorization # 364

Receiving: 8/2/12 Freight Company: MUSTANG HELI Prepaid ☐ Collect ☐  
 Date Received: 8/2/12  

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
5	D2350	33777	Letter tie down Bracket	<u>Done</u>	<u>8/2/13</u>

Condition of packaging: Good Photograph required: yes ☐ no ☒  
 Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC: Quarantine: Location: QC Condition of Part: good  
 Inspect: Initial: [Signature]

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
S	D2350	B33777	re-power coat qty 2 of 5 (due to the original process not being a nice finish) re-assemble qty 2, and re-stock per W/O → Stock 3 per W/O →	<u>[Signature]</u>	<u>37457</u>	
					<u>37458</u>	

QA Coordinator: Advise GM as to findings: Initial: \_\_\_\_\_ Date: \_\_\_\_\_  
 Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

Issue credit: yes <input type="checkbox"/> no <input type="checkbox"/>	Invoice Amount: _____
GM Approval: _____	Less Replacement: _____
Date: _____	Restock Fee: _____
	Freight: _____
	Net Credit: _____
	DHS <input type="checkbox"/> Customer <input type="checkbox"/>

QA: Enter into Q-Pulse with reason for return & File original. Signed: \_\_\_\_\_ Date: \_\_\_\_\_  
 Copy of Customer Return to stay with work orders and another copy to be filed with customer credit